

Work Order ID 75285

75285

Page 1

October-20-11 9:55:00 AM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2563 | Rev C | | | | | | | | |

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563
 2-Deburr ends
 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343
 4- Grind
 110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

Handwritten notes and signatures:
 11.11.02
 2
 2 0 BE11/11/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 75285



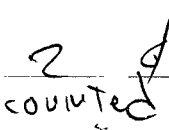
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|---|---|----------------------|---------|--------|--------------|---|---|------------------|----------------|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | |  | | | |
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 2 |  | | |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 2 |  | | |

Swlu/07

11-11-07

2 of 11 u/11/07 counted

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Page 3

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|-----------------|--------------|---------------|---------------|------------------|----------------|
| 150 *150* Large Fab Large Fab | Weld per dwg A/R Aluminum rod Batch: <u>114514</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig End cap as per Dwg D2563 using DT 8343 3-Grind | 0.00 0.00 | | <u>11.11.09</u> | | <u>2</u> | <u>0</u> | | |
| 160 *160* QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | <u>Sulu</u> | | | | | |
| 170 *170* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | <u>Sulu</u> | | <u>(+2)</u> | | | |

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Page 4

October-20-11 9:55:00 AM

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 175 *175* HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo Touch up Alodine as per QSI005 | 0.00 0.00 | | | | | | | 2X Ø M/L 11/11/11 |
| 180 *180* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 10:15 OVEN TEMPERATURE: 320 FINISH TIME: 10:45 118988. | 0.00 0.00 | | | | | | | 2X Ø M/L 11/11/11 |
| 190 *190* HandFinish Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch Memo | 0.00 0.00 | | | | | | | 2 PR 11.11.14. |

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October-20-11 9:55:00 AM

75285

Page 5

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|--|
| 200 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *200* QC Quality Control | Memo | 0.00 | | | | | | | 2x of M 11/11/14 COUNTED & MEASURED |
| 210 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *210* Packaging Packaging | Memo | 0.00 | | | | | | | PP 75289 11/11/14 (20) |
| 220 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *220* QC Quality Control | Memo | 0.00 | | | | | | | 11/11/15 |

11/11/15
(2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

October-20-11 9:55:05 AM

Page 1

Work Order ID: 75285

75285

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--------------------|--|--------------|----|--|--|-----|------|---------|----|---|--|----------|--|
| D2244-116 | | Manufactured | No | | | 100 | Each | 97.5000 | 1 | 2 | | | |
| *D2244-116* | | | | | | | | | ** | | | 11-11-02 | |
| Step Extrusion | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL | 91 | |
| 60307 | 91 | |
| WA | 6.5 | |
| 60307 | 6.5 | |

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|----|---|--|----------|--|
| D2561 | | Manufactured | No | | | 100 | Each | 19.0000 | 2 | 4 | | | |
| *D2561* | | | | | | | | | ** | | | 11-11-02 | |
| Lug | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 14 | |
| 71590 | 14 | |
| WA015 | 5 | |
| 66813 | 5 | |

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|----|---|--|----------|--|
| D2564 | | Manufactured | No | | | 100 | Each | 42.0000 | 2 | 4 | | | |
| *D2564* | | | | | | | | | ** | | | 11-11-02 | |
| Mounting Angle | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 42 | |
| 69286 | 12 | |
| 71591 | 30 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

October-20-11 9:55:05 AM

Page 2

Work Order ID: 75285

75285

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2673-34

Manufactured No

100

Each

55.0000

1

2

D2673-34

End Plate

**

11.11.02

Location

Loc Qty

Loc Code

WA

35

69534

35

2

WA015

20

59690

20

D2673-34

Manufactured No

150

Each

55.0000

1

2

D2673-34

End Plate

**

11.11.09

Location

Loc Qty

Loc Code

WA

35

69534

35

2

WA015

20

59690

20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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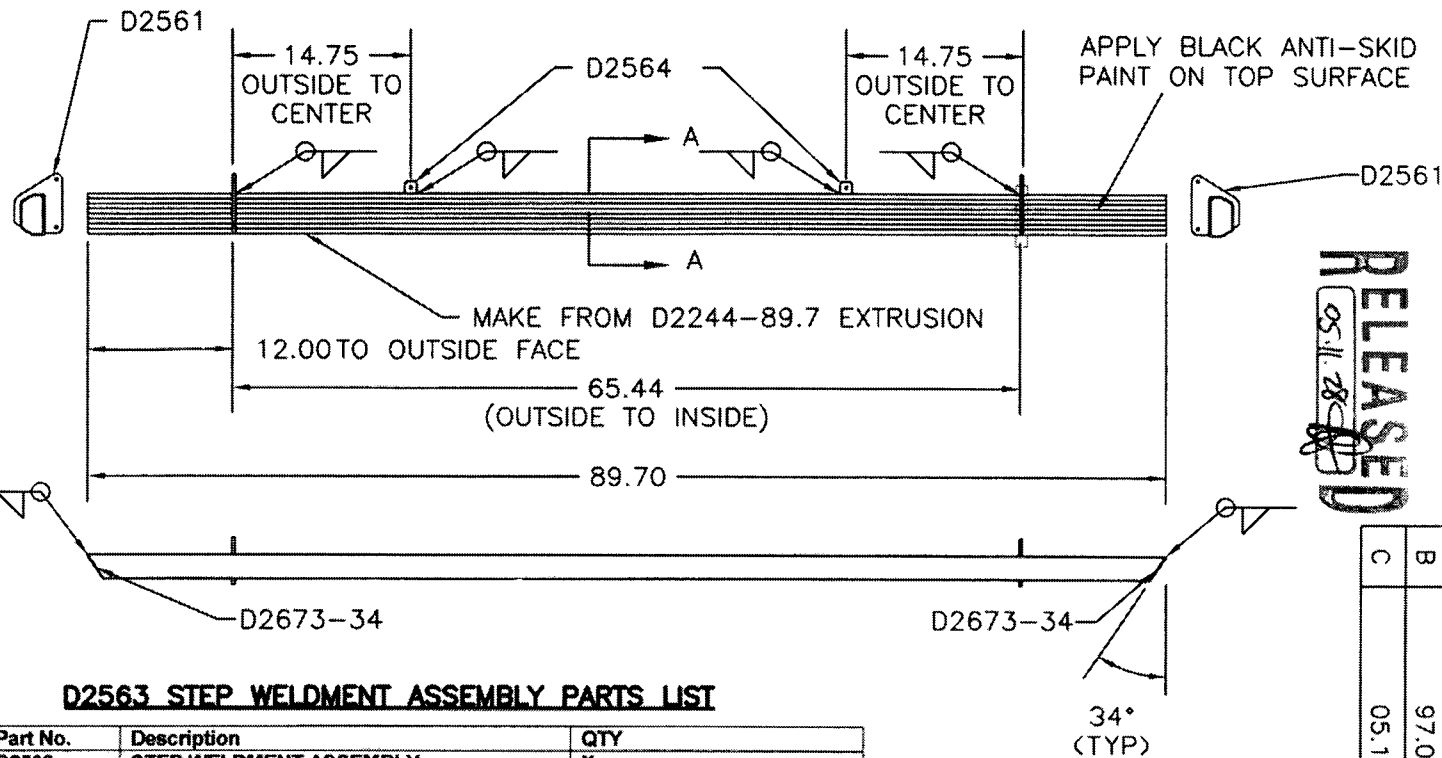
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NOTE: Date & initial all entries



RELEASED
05.11.28

| | | | | |
|---------|----------|------------------------------|-------|-----------------------------|
| DESIGN | BW | DRAWN BY | 47 | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.11.14 | TITLE | D2563 | REV. C |
| | | STEP WELDMENT ASSEMBLY | | SHEET 1 OF 1 |
| | | SCALE | 1:15 | |
| A | 96.04.26 | NEW ISSUE | | |
| B | 97.05.14 | END CAPS CHANGED (WAS D2248) | | |
| C | 05.11.14 | UPDATE NOTES | | |



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

| Part No. | Description | QTY |
|------------|------------------------|-----|
| D2563 | STEP WELDMENT ASSEMBLY | X |
| D2244-89.7 | EXTRUSION* | 1 |
| D2561 | LUG PLATE | 2 |
| D2564 | MOUNTING ANGLE | 2 |

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 75285 M.C.5 11/10/20

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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